

OK NiCrMo-3

Ni-based CrMoNb electrode for welding of Ni-alloys of the same or similar type as e.g. Inconel 625, for welding of 5% and 9% Ni steel. The electrode is very suitable for welding of 254 SMO, i.e. UNS S31254 steel.

Specifications	
Classifications	SFA/AWS A5.11 : ENiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)
Approvals	CE : EN 13479 DNV-GL : -H5 NAKS/HAKC : 2.5-4.0 mm VdTÜV : 12414

Welding Current	DC+
Ferrite Content	FN 0
Alloy Type	Ni-based CrMoNb
Coating Type	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	500 MPa	780 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-196 °C	50 J
As Welded	20 °C	70 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	Nb	Fe
0.03	0.2	0.4	62.8	21.7	9.3	3.3	2.0

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	55-75 A	23 V	55 %	100	40 sec	0.9 kg/h
3.2 x 350.0 mm	65-100 A	25 V	56 %	49	52 sec	1.4 kg/h
4.0 x 350.0 mm	80-140 A	27 V	58 %	33	57 sec	1.9 kg/h
5.0 x 350.0 mm	120-170 A	24 V	58 %	21	72 sec	2.1 kg/h